

Date: Thursday, 12/13/2007 2:39:12 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : RING
Job Number : 36332B	
Estimate Number : 10395	
P.O. Number : <u>N/A</u>	Part Number : D29685
This Issue : 12/13/2007 S.O. No. : <u>N/A</u>	Drawing Number : D2968
Prsht Rev. : <u>NC</u>	Project Number : <u>N/A</u>
First Issue : <u>N/A</u> Type : MACHINED PARTS	Drawing Revision : C
Previous Run : 34196B	Material : <u>N/A</u>
Written By : <u>[Signature]</u>	Due Date : 1/15/2008
Checked & Approved By : <u>[Signature]</u>	Qty: 50 Um: Each
Comment : Est: C 03.04.11 Reformat; Incorporated D2968-1/-5 KJ/RF	
Est: D 07.08.23 Rev C dwg EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M4130NT3000W500	4130 Tube 3"ODx.5"W
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Comment: Qty.: 0.0587 f(s)/Unit Total : 2.9348 f(s)
 Material: AISI 4130 Ø 3.00 .500" WALL " Bar
 (M4130N-R0.750) Batch: M103452
 Identify AS D2968-1

J.F. 07/12/17

2.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
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Comment: MORI SEIKI LATHE
 1-Turn Blank as per Folio FA049 and Dwg D2968
 2-Deburr, no sharp edges

J.F. 07/12/17 (SS)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 07/12/17 (SS)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SA 07.12.17 (SS)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Identify and Stock
 Location: PAT D

[Signature] 07/12/18 (SS)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 07/12/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RING

Job Number: 36332B

Part Number: D29685

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



55

Comment: FINAL INSPECTION/W/O RELEASE

2007/12/19

Job Completion



2007/12/19

W

103

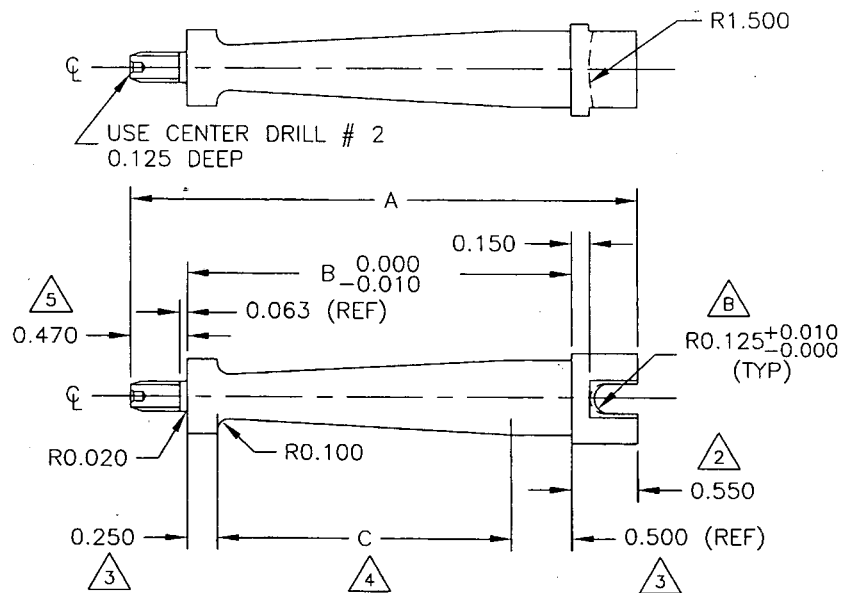
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



PART NUMBER	A	B	C
D2968-1	5.040	4.020	3.270
D2968-3	4.200	3.180	2.430

D2968-1/-3 STEM

D2968-1 AND D2968-3 STEM:

- 1) MATERIAL: AISI 4130N ROUND BAR PER MIL-S-6758
OR AMS 6348/6370/6528
(REF DART SPEC M4130N-RX.XXX)
- 2) $\phi 0.750$ O.D.
- 3) $\phi 0.625$ O.D.
- 4) MACHINE UNIFORM TAPER FROM $\phi 0.363$ O.D.
TO $\phi 0.625$ O.D.
- 5) 1/4-28 UNF THREAD WITH 0.063 GRIP
- 6) MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
UNLESS OTHERWISE INDICATED
- 7) ALL DIMENSIONS ARE IN INCHES
- 8) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED

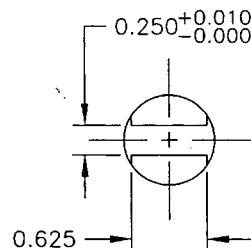
D2968-5 RING:

- 9) MATERIAL: AISI 4130N TUBING PER MIL-T-6736
OR AMS 6360/6361/6362/6371/6373/6374
(REF DART SPEC M4130NT3000W500)
- 10) ALL DIMENSIONS ARE IN INCHES
- 11) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

NO. 36332 JB
 WORK ORDER
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 UNCONTROLLED COPY
 ENGINEERING
 RETURN TO
 SHOP COPY

R0.125 $\frac{0.000}{-0.010}$

D2968-5 RING



D2968-5 RING

1/8

USE D2968-1 STEM
FOR -041
USE D2968-3 STEM
FOR -043

D2968-041 AND D2968-043 TOW RING:

- 12) WELD PER QSI 004 ON ALL EDGES BETWEEN STEM AND RING
- 13) HEAT TREAT TO MIN ULTIMATE TENSILE STRENGTH OF 125 KSI
- 14) FINISH: CAD PLATE ENTIRE ASSEMBLY PER
QQ-P-416F CLASS I TYPE II
POWDER COAT WHITE (REF 4.3.5.2) PER DART
QSI 005 4.3 (EXCEPT THREADS)

C	07.04.17	2.050 WAS 2.000, UPDATE NOTES
B	00.05.31	R0.125 AND R0.210 WERE 0.060 x 45°
A	00.03.07	NEW ISSUE
DESIGN	<i>[Signature]</i>	DRAWN BY <i>[Signature]</i>
CHECKED	<i>[Signature]</i>	APPROVED <i>[Signature]</i>
DATE	07.04.17	TITLE
		TOW RING

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DART

DART AEROSPACE LTD.
HAMMERSBURG, ONTARIO, CANADA

DRAWING NO.

D2968

REV. C

SHEET 1 OF 1

SCALE

1:1

RELEASED
 07.06.18